

Date: Monday, 5/14/2007 7:13:47 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HARNESS ASSEMBLY	
Job Number	32332		Part Number	D412702101B	
Estimate Number	12854		Drawing Number	ICA D412-702 P.79	
P.O. Number	N/A		Project Number	N/A	
This Issue	5/14/2007		Drawing Revision	D	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	5/15/2007	
Previous Run	N/A		Qty:	1	
Written By			Urn:	Each	
Checked & Approved By			<i>SK 2</i>		
Comment	est rev A 07.05.10 new issue EC				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description:			
1.0	DC	DOCUMENT CONTROL			
		 <i>PTO</i>			
Comment: DOCUMENT CONTROL type labels per PPP D412-702-101B CHG001					
2.0	D35737	ADAPTER			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s) ADAPTER batch: <i>B31864-</i>					
3.0	D3579046	SHOULDER HARNESS RH			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s) SHOULDER HARNESS RH batch: <i>B32115</i>					
4.0	K62	CLIP			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s) CLIP batch: <i>M104426</i>					
5.0	MS24693S272	Screw			
					
Comment: Qty.: 4.0000 Each(s)/Unit Total : 36.0000 Each(s) Screw batch: <i>M 896? 25X-</i>					
<i>✓ ml07/05/07</i>					

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARNESS ASSEMBLY

Job Number: 32332

Part Number: D412702101B

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD10LL Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

batch: M11763

7.0 MS21042L3 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut

batch: M104215

8.0 D35693 DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

DECAL

batch: B 32086

ml07/05/17

9.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per dwg ICA D412-702 p.79

ml07/05/17

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml07/05/17 (2)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-101B CHG001

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

ml07/05/17 (2)

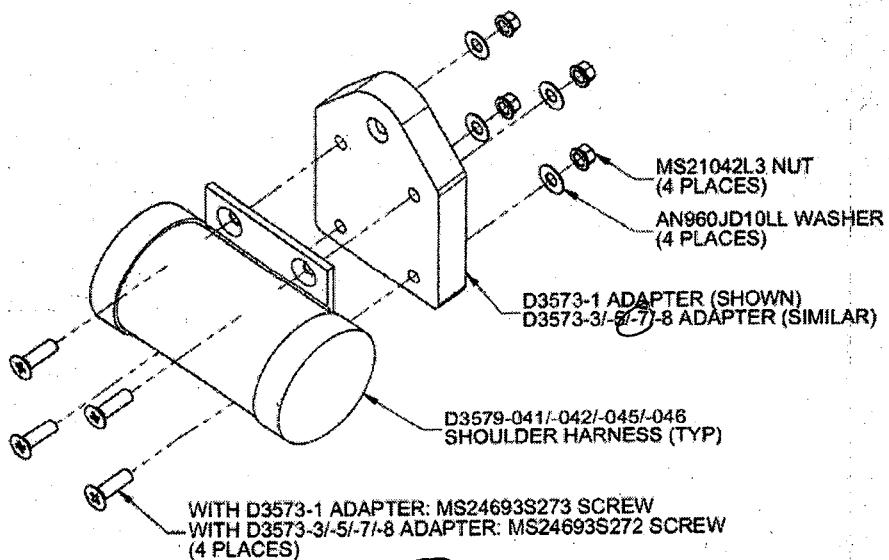
ml07/05/17 (2)

Job Completion

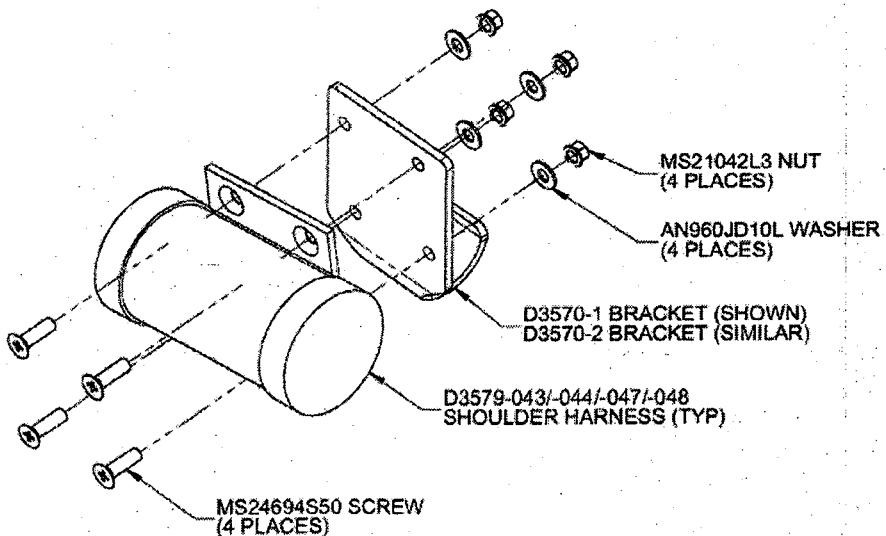


Inspection level 21

ml07/05/17



DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND  
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B HARNESS ASSEMBLIES  
(BELTS, K6.2 CLIP AND D3569-1/-2/-3 DECAL NOT SHOWN)



DETAIL 'L' D412-702-111A/-111B/-113A/-113B HARNESS ASSEMBLIES  
(BELTS AND D3569-1/-2/-3 DECALS NOT SHOWN)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22332

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25-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/17	1	w/o split again	ml	07/05/17	2	✓ 07/05/17	✓ 07/05/17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/17	8	D3569-3 do not stick	LE 07.05.17	Use contact cement M102565 SEE ATTACHED EMAIL FROM SCHROEDER	ml 07/05/17	✓ 07/05/17	LE 07.05.17	✓ 07/05/17

NOTE: Date & initial all entries

## Leanne Elsiger

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**From:** Marianne Kump [Marianne.Kump@armorholdings.com]  
**Sent:** May 16, 2007 1:57 PM  
**To:** Leanne Elsiger  
**Subject:** FW: Crazy Glue on Buckle

### *Marianne Kump*

Marianne Kump  
Engineering  
Schroth Safety Products  
(954) 784-3178 x 305  
(954) 784-3179 (fax)

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**From:** Marianne Kump  
**Sent:** Wednesday, May 16, 2007 11:43 AM  
**To:** 'Leanne Elsiger'  
**Cc:** Jeff Schlueter; Jack Ziros  
**Subject:** FW: Crazy Glue on Buckle

Leanne,

Per our conversation this email is to approve the change of the temporary adhesive from "Krazy Glue" to LePaige Contact Cement LCP506.

All other details below still apply.

Best regards,

### *Marianne Kump*

Marianne Kump  
Engineering  
Schroth Safety Products  
(954) 784-3178 x 305  
(954) 784-3179 (fax)

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**From:** Marianne Kump  
**Sent:** Wednesday, May 16, 2007 11:09 AM  
**To:** 'Leanne Elsiger'  
**Cc:** Jeff Schlueter; Jack Ziros  
**Subject:** RE: Crazy Glue on Buckle

Leanne,

Schroth Safety Products will allow the addition of the decal using "Krazy Glue" for the one shipment of restraints with SL 20 plastic buckles shipping today only. Schroth will not take responsibility for any failures of the housing due to the addition of the Krazy Glue to the plastic housing.

We will provide you with the name of a suitable bonding material in the near future so that DART can add the decal without voiding the restraint warranty.

Please note that under no circumstances does this email approve Krazy Glue to be used on and SL 36 buckles.

Please provide part numbers and quantity of restraints in today's shipment will include so that we can add this information to our manufacturing file.

Best regards,

*Marianne Kump*

Marianne Kump  
Engineering  
Schroth Safety Products  
(954) 784-3178 x 305  
(954) 784-3179 (fax)

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**From:** Leanne Elsliger [mailto:[lelsiger@dartaero.com](mailto:lelsiger@dartaero.com)]

**Sent:** Tuesday, May 15, 2007 4:01 PM

**To:** Marianne Kump

**Subject:** Crazy Glue on Buckle

Marianne – we'd like to have a decal adhered with crazy glue (edges only) to one side of the plastic buckle casing of SL 20 and SL36.L9/R9. Since the casing is not a structural component of the buckle, is this acceptable?

Thanks,  
Leanne

Leanne Elsliger, P.Eng  
Design Engineer  
Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawkesbury, ON, K6A 1K7  
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